

Date: Thursday, 9/21/2006 3:24:23 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : NUT PLATE ASSEMBLY
 Job Number : 28695
 Estimate Number : 11054
 P.O. Number : N/A
 This Issue : 9/21/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : MACHINED PARTS
 Previous Run : 28076
 Written By :
 Checked & Approved By :
 Comment : Est A05.09.13 New issue KJ/JLM

Part Number : D2873045
 Drawing Number : D2873 REVA
 Project Number : N/A
 Drawing Revision : A
 Material : N/A
 Due Date : 9/30/2006 Qty: 20 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0375X01000 6061T6 BAR



Comment: Qty.: 0.2363 f(s)/Unit Total : 4.7250 f(s)
 6061T6 BAR
 Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-225/8)
 (M6061T6B0.375x01.000)
 Identify for D2873-5
 Batch: M101926

J.F. 06/10/22 20

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut blanks: 1.000" x 0.375" x 2.700" long

J.F. 06/10/22 20

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA and Dwg D2873
 Identify as D2873-5 Dwg Rev A Folio Rev AA

J.F. 06/10/23 20

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/10/23 20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/21/2006 3:24:23 PM
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Process Sheet

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Drawing Name: NUT PLATE ASSEMBLY

Job Number: 28695

Part Number: D2873045

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 06.10.23

20

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Debur

2- C'sink as per Dwg D2873

mloc 10/27

20

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/10/31

20

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

am 06/10/31

20

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION

FF 06-11-02

20

10.0

MS20426AD46

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

Rivet

Pick;

Qty

Part Number

Description

Batch

4

MS20426AD4-6

Rivet

M12930

FF 06-11-03

20

11.0

MS21075L5

Nut Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

Nut Plate

Pick;

Qty

Part Number

Description

Batch

2

MS21075L5

Nut Plate

M18136

FF 06-11-03

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: AS Date: 06/11/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/21/2006 3:24:23 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE ASSEMBLY

Job Number: 28695

Part Number: D2873045

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D2873

2-Identify as D2873-045

FF 06-11-03

20

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/11/03

20

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57392

06/11/06

15.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

LD 06/11/07

Job Completion



11 26-11-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 28695
Description: RADIUS BLOCK		Part Number: 2873- 5 ⁵
Inspection Dwg:	Rev: A	Page 1 of 1

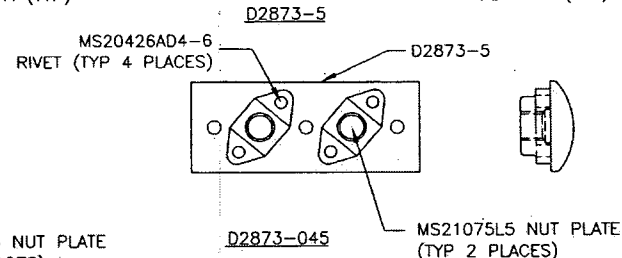
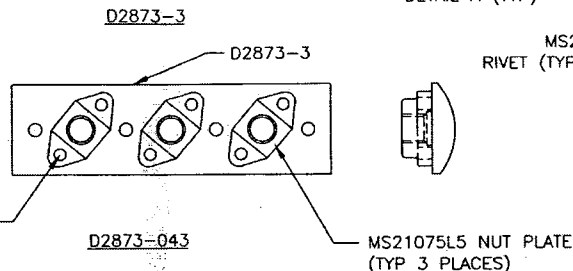
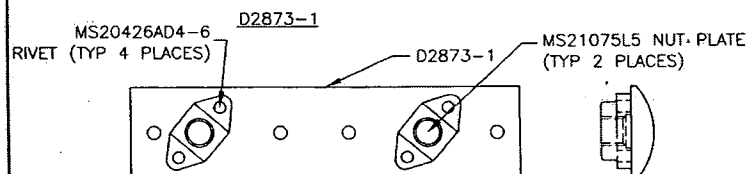
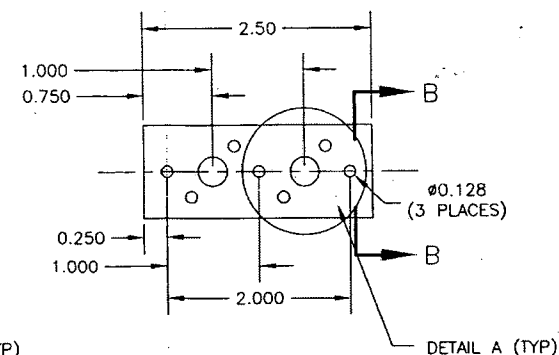
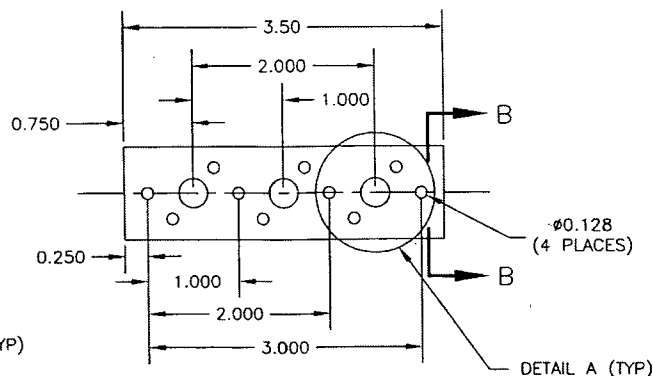
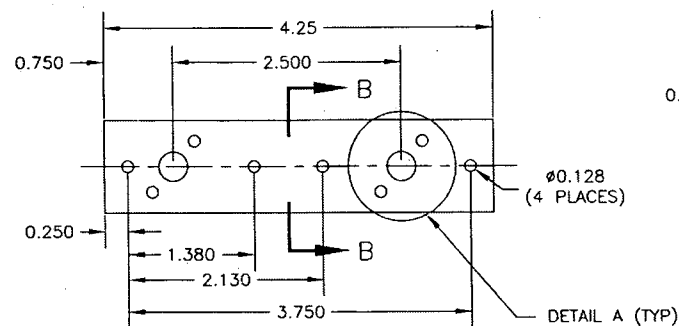
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50"	±.030"	2.504"	✓			
1.000"	±.010"	1.001"	✓			
.750"	±.010"	.751"	✓			
Ø.128"	±.005"	Ø.131"	✓			
.250"	±.010"	.254"	✓			
1.000"	±.010"	1.004"	✓			
2.000"	±.010"	2.004"	✓			
.061"	±.010"	.061"	✓			
1.000"	±.010"	1.003"	✓			
.250"	±.010"	.250"	✓			
R0.800"	±.030"	R0.800"	✓			
.359"	±.010"	.363	✓			
Ø.316"	±.004"	Ø.318"	✓			
Ø.230"	±.010"	Ø.227	✓			
.125"	±.010"	.115"	✓			

Measured by: J.F.	Audited by: J.G.	Prototype Approval: N/A
Date: 06/10/22	Date: 06/10/23	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D2873-041

MS20426AD4-6 RIVET (TYP 6 PLACES)

D2873-043

MS21075L5 NUT PLATE (TYP 3 PLACES)

D2873-045

MS21075L5 NUT PLATE (TYP 2 PLACES)

D2873-1/-3/-5 RADIUS BLOCK

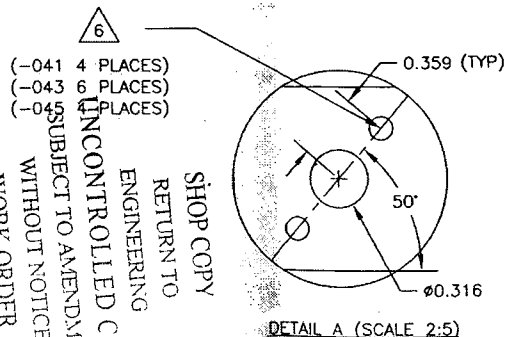
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X00.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X00.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 x 100'

D2873-041/-043/-045 NUT PLATE ASSEMBLY

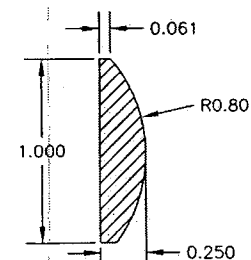
- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



DETAIL A (SCALE 2:5)



SECTION B-B (SCALE 2:5)

NO. 28695
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

A	05.07.26	NEW ISSUE
DESIGN PH	DRAWN BY PH	DART DART AEROSPACE LTD HAMMERSLEY, ONTARIO, CANADA
CHECKED DS	APPROVED DS	DRAWING NO. D2873
DATE 05.07.26		TITLE RADIUS BLOCK
		REV. A SHEET 1 OF 1 SCALE 4:5

RELEASED
05-07-26